Work Order I March-01-13 1:51:1			*97¢	39*						Page 1
Revision ID:	,		Accept .	*N900 Cust Item Customer:	ID:	100	<b>)*</b> s	Setup Sta Sto	1/1	S1* S2*
Approvals: Pro	ocess Plan: _MCT	Date: <u>/3-03-0</u>	Y Tooling:	D	ate:	_	F	Run Sta	1/1	R1*
QC		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					- Tribe San				
D4030	С	nsp								
100	Pick Kit		0.00							$\sim$
*100* Packaging Packaging	Memo		0.00				(X		1	3-4-2
			·							
*110 *110* HandFinish	Assemble as per dw		0.00				/	\$	BL 10	3- 4 <b>-</b> 24
Hand Finishing	****M	ask label plate to size of D408 ea for label, apply label ****	86 label, use scotchbrite red	d pad to lightly						
120 *120*	QC5- Inspect part c	completeness to step on W/O	0.00 AS	. '			j			
QC Ouality Control	Memo		0.007424	•						<del></del>

NCR:	Yes	/ No		•		WORK ORDER NON-C	COL	NFORM	MANCE / UP	DATE		,			
											(	QA Closed:	D	ate:	
Marile Ond		•				DISPOSITION				AGAINST D	EP	PARTMENT	/PROCESS		
Work Ord	er:				·	Rework			Skid-tube	Crosstube			Water Je		Engineering
Part I	No.					Scrap			Machining	Small Fab	4		d. Eng. Coo	$\rightarrow$	Quality
NCR I	No.					Use-as-is Work Order Update	]	i	noforming Large Fab	Finishing Composite		Rec/Stoi	re/Packagin Supplie	_	Other
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &		,	
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	$\downarrow$	Date	Verificati	on	QC Inspector
Doc/Data															
Equip/Tooling													`		
Operator	-			}							١				
Material Setup	$\vdash$												1		
Other	┢														ļ
Process	-										1				
Supplier															
Training											١		İ		
Unapproved															
						F.	AUL	T CATE	GORY						
Landi	ng (	Gear			<b></b>	General		1		_	_	ı		<b></b>	<b>1</b> .
	L	Bending			<u> </u>	Bend		Grain		_		Ovalized		<u> </u>	Pressure/Forced
	L	Centre No	ot Concei	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		-	_	Over/Under		-	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	-	4	ion Incomplete	, <u> </u>	$\dashv$	Part Incorre		<u> </u>	Weld
	_	Crushed/	Crimped.	-	<u> </u>	Burrs	$\vdash$	1	ions Incomplete/	Unclear	↤	Part Lost/M	•	L	Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	<u> </u> -	Mainte		-	-1	Part Moved			
	<u> </u>	Heat Trea		<b>+</b> 1	<u> </u>	Countersink	-	Mislabe		<u> -</u>	-	Positioned \	_		Jothan
	1	Inspectio	n Strip in	Tube	1	Cut Too Short	1	Misread	ג	<b>I</b>	- 1	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Work Ord		7939		*979	39*							Page 2
Item ID: Revision ID: Item Name:	D4030-041 Long Basket	Assembly (350)		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date Reference:	3/12/13 e: 3/12/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	,	Cust Item II Customer:	<b>D:</b>						
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		te:			Run	Start		R1* R2*
Sequence ID/ Work Center 130 *130* Packaging Packaging	ID	Operation Description Identify as per dwg & St		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qt	y .	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection -	- Work Order Release	0.00					MUS	5	13-01	4-25

W 130625

NCR: Y	es /	No					WORK ORDER NON-O	O	VFORM	ANCE / UPI	DATE	•		
•												QA Closed:	Date:	
Work Orde	r:						DISPOSITION	_			AGAINST DE	PARTMENT/	PROCESS	
Part N	o						Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o						Work Order Update	]		Large Fab	Composite		Supplier	
Root					Des	cri	otion of work order update	I	nitial	Act	ion	Sign &		
Cause	0	ate	Step	Qty		C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved													·.	
		•					F.	AUL	T CATE	GORY				
Landin	g Gear	•					General					_	_	
-	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance Ied	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Tur	ning Se	equence				Finish	1	Out of S	equence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

March-01-13 1:51:17 PM

Work Order ID:

97939

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date: 3/12/13** 

Required Date: 3/12/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC 10.04.20 verified by:EC

IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement	Mfg/	Bin	Primary	Last Location	Route	Unit of Measu		Qty per Kit		Qty Issued	Date Issued	Status
	Item ID	Purch	Item	Location	- Location	Seq ID			<u> </u>	Qty	Issueu	188000	
D4086-200		Manufactured	No				Each	14.0000		1 (			
Placard, Max Load									<del>&lt;:</del>	5 - 72 - 17	79/		
				<b>Location</b>		Loc Qty		Loc Code			<b>J</b> ,		
				ST093		14				<del></del>			
				886		5				<del>-)</del>			
				962	251	9				<del>-{X</del>			
D2530		Manufactured	No	-		100	Each	3.0000	1	1	B86	3(00	00
Handle Weldment												<u></u>	-9E
				<b>Location</b>		Loc Oty		Loc Code					
				ST255		3			<del></del>				
				944	174	3							
D2535		Manufactured	No			100	Each	106.0000	2	$\mathcal{Q}^2$			
Spring									C	Q			
				Location		Loc Qty		Loc Code					
•				ST011		106							
				863		6							
				925		50				$\sim$			
				962	248	50				<u>X</u>			
D2537		Manufactured	No		• •	100	Each	94.0000	2	$c^2$	13-4	- 7 3	
Bushing					٠			• •			7 1 2 - 9.		et
		•	•	<b>Location</b>		Loc Qty		Loc Code	-				
				ST011		94							
				875		30							
				92	711	24				2x			
						40							
D3913-041		Manufactured	No		97937	100	Each	0.0000	1	$\int_{-\infty}^{\infty}$	12/	3-4-2	2
Long Basket Base Assemb	by, 350					• • • •	<b>.</b> .		<del></del>			13-4-5. 13-4-2	<u></u>
D3914-041		Manufactured	No		97923	100	Each	0.0000	1	/ 1	BI	3-4-2	2
Long Basket Lid Assembl	y (350)								4-12-4			<u> </u>	

										DQA:	Date:	
NCR: Y	res / N	o			WORK ORDER NON-O	cor	VFORI	MANCE / UPE		0.6		
· · · · · · · · · · · · · · · · · · ·		<del></del>		**	<b></b>			<del></del>		QA Closed:	Date:	- W. T
					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er:				Rework	1		Skid-tube	Crosstube	[	Water Jet	Engineering
Part N	.lo				Scrap	1 1		Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	····				Use-as-is	1 1		noforming	Finishing		e/Packaging	Other
NCR N	No				Work Order Update		1110111	Large Fab	Composite	1100,0101	Supplier	
						_				1		
Root				Descri	ption of work order update	Ti	nitial	Act	ion	Sign &		
Cause	Dat	e Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												, '
Other										:		
Process			,					,				
Supplier												
Training												
Unapproved		1	<u> </u>	<u> </u>		<u> </u>	T CATE	CORY		<u>L</u>		
1 11:	6				General	AUL	ICATE	GURY				
Landii	n <b>g Gear</b> Bendi				Bend		Grain		<u></u>	Ovalized		Pressure/Forced
		ਾਂਡ e Not Conce	ntric to		BOM/Route	-	Hardwa	oro		Over/Under	tolerance	Temperature/Cure
	Cracks		mune to	<sup>0/3</sup>  -	Broken/Damaged	$\vdash$	-1	ion Incomplete		Part Incorre	h	Weld
	<b>⊢</b>	· ed/Crimped		-	Burrs	-	1	tions Incomplete/L	Inclear	Part Lost/M		Wrong Stock Pulled
	Cuffs	Lu, Crimpeu	-	-	Contamination	<b>+</b>	4	enance	-	Part Moved		7 20 2.220 2.100
	Heat 1	reat		<u> </u>	Countersink		Mislabe			Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID:	97939							•	2/12/12	D 4 1D 4 2/12/12
Parent Item:	D4030-041								<b>Date:</b> 3/12/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Assemb	oly (350)		•				Star	t Qty: 1.00	Required Qty: 1.00
<b>D3917-3</b> Washer		Manufactured	No			100	Each	78.0000	6	686
				Location		Loc Oty		Loc Code		
				ST072		78				
				-	92514	17				<u> </u>
					94136	5				
					94137	6				
					94643	50			(	<u>2</u> X
D3953-3		Manufactured	No	•		100	Each	41.0000	2	2
Gas Spring Stud, Lid										-8P
				<b>Location</b>		Loc Qty		Loc Code		Ol
				GA		1				
					87592	1				
				ST076		40				
					88494	14				· <del>······</del>
					94744	26			2.	X
D3953-7		Manufactured	No			100	Each	53.0000	2	200
Spring Spacer		Transacture Cu								
				Location		Loc Qty		Loc Code		
				ST076		53				
					88393	1				
					89248	12				
					94669	40			$\overline{a}$	$\overline{\lambda}$
D3953-9		Manufactured	No			100	Each	91.0000	2	2
Gas Spring Washer		Manufactured							<	2013-4-73.
ob0 no				I aastis-		Loc Qty		Loc Code		04
			-	Location				Luc Coue		
				ST076	0.4510	91				<del></del>
					94719	46			<u></u>	<u> </u>
	•				95127	45				<del></del>

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORIN	ANCE / UP	DATE					
						<b></b>						QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST (	DE	PARTMENT	/PROCESS		
Work Ordi	C1.	<del></del>			<del></del>	Rework	]		Skid-tube	Crosstube			Water Jet	-	Engineering
Part I	No.		-			Scrap		Ī	Machining	Small Fab			d. Eng. Coor	$\vdash$	Quality
NCR I	No.		<u></u>	- · · · · · · · · · · · · · · · · · · ·	<del></del>	Use-as-is Work Order Update	]	•	Large Fab	Finishing Composite		Rec/Stoi	re/Packaging Supplie	-	Other
Root					Descri	ption of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	iption		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling															
Operator				·											
Material															,
Setup	Ш														
Other	Ш														
Process	Ш														
Supplier	Н														
Training	Н		<u> </u>												
Unapproved		.,	<u> </u>	<u> </u>			<u> </u>	T CATE	SORV			L	ł		<u> </u>
Landi	na C				·	General	AUL	LICAIL	JONT						
Landi		Bending				Bend	Г	Grain		ſ	_	Ovalized		<u></u>	Pressure/Forced
	H	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	Ì		Over/Under	tolerance		Temperature/Cure
	H	Cracks				Broken/Damaged		4	on Incomplete			Part Incorre			Weld
	П	Crushed/	Crimped.			Burrs		1	ions Incomplete/L	Inclear		Part Lost/M	issing		Wrong Stock Pulled
	-	Cuffs	•			Contamination	Г	Mainte	nance	ļ		Part Moved			_
	П	Heat Trea	ıt ,			Countersink		Mislabe	led			Positioned \	Vrong	_	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I			Power Loss/	'Surge		Other
	П	Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Outside Dimensions

Out of Sequence

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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	97939							
Parent Item:	D4030-041						Date: 3/12/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Assembly (350)					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
D3953-17 Gas Spring Spacer	Manufactured	No		100	Each	27.0000	2	2 50
,			<b>Location</b>	Loc Qty		Loc Code		
			ST076	27			<del> </del>	<u> </u>
			89180	15				1.
			94578	12				<u>K</u>
D3953-19 Gas Spring Bracket	Manufactured	No		100	Each	12.0000	1	\$6
			Location	Loc Qty		Loc Code		
			ST077	12				
			92819	12			<i>!X</i> _	
D3953-21	Manufactured	No		100	Each	14.0000	1	100
Gas Spring Bracket								- 3/-
			Location	Loc Qty		Loc Code		
			ST077	14				
			85759	2				
			94146	12			/<	
D3969-3 Spring (Basket Lid)	Manufactured	No		100	Each	24.0000	1	1 50
			Location	Loc Qty		Loc Code		•
			ST262	14				
			91844	14			(X	\$
•			ST272	10				<u> </u>
			97050	10				
AN3-14A Bolt	Purchased	No		100	Each	145.0000	. 4	CD 13-4-23
•			<b>Location</b>	Loc Qty		Loc Code		01
			ST352	45				
			122800	45				<del></del>
			ST512	100				
			123759	100			<del></del> 4	X

										DQA:	Date	
NCR: Y	res / N	lo			WORK ORDER NON-C	CON	FORN	MANCE / UP	DATE	QA Closed:	 Date	
				:	DISPOSITION	T			AGAINST DE			
Work Orde	er:				DISPOSITION	.			<del></del>	, Altitiviciti)	<b></b>	
Part N	No		1, <del>1</del>		Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No				Work Order Update	1		Large Fab	Composite	i necystor	Supplier	
Root		F	T	Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		İ									· ·	
Operator			-									
Material												
Setup			İ									
Other												
Process	_											
Supplier	_											
Training			ļ									
Unapproved	<u> </u>		<u> </u>	l	_	1	6475	CORV		L	<u> </u>	
		<del> </del>	-	·	<del></del>	AULI	CATE	JURY				
Landır	ng Gear				<b>General</b> Bend		Grain			Ovalized	Г	Pressure/Forced
	Bendi	ng e Not Conc	antria ta	~ F	BOM/Route	$\mathbf{H}$	ardwa Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Crack		entric to	<sup>0/3</sup>  -	Broken/Damaged			on Incomplete		Part Incorre	·	Weld
	<del></del>	s ed/Crimpe	d	-	Burrs	$\mathbf{H}$	-	ions Incomplete/	'i Inclear	Part Lost/M	<b>⊢</b>	Wrong Stock Pulled
	Cuffs	eu/Cimpe	u.		Contamination	_		nance	Officient	Part Moved	· _	
	Heat	[reat			Countersink	$\vdash$	viainte Viislabe		<del> </del>	Positioned V		
,	_	ction Strip i	n Tuhe	-	Cut Too Short	<b>—</b>	Misread			Power Loss/	_	Other
		es in Bend	ii iubc	-	Drill Holes	-	Offset	,	<u> </u>	J. 3116, 2333/		1
		e Waves in	Extrusio	,	Drawing	$\vdash$		Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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## **Picklist Print**

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Work Order ID:	97939											
Parent Item:	D4030-041								Start 1	Date: 3/12/13		Required Date: 3/12/13
Parent Item Name:	Long Basket Assem	nbly (350)							Start	<b>Qty:</b> 1.00		Required Qty: 1.00
AN3-16A Bolt		Purchased	No			-	100	Each	144.0000	2	2	8
				Location	<u>1</u>		Loc Qty		Loc Code			
				GA	117441	٠	4 4					
				ST352			9.					
					122407 123900		4'	7			<del></del>	
AN5-17A Bolt		Purchased	No				100	Each	140.0000	4	4	W 139802 86
				Locatio	1		Loc Qty		Loc Code			
				GA			30					
					117872		30					
				ST337			10-	ļ				
					123831		5					
					124215		50	)				
AN4-12 Bolt		Purchased	No				100	Each	45.0000	3	3	80
				Locatio	<u>n</u>		Loc Oty		Loc Code			,
				ST356			4:					
					122800		4:				30	
<b>AN310-4</b> NUT		Purchased	No		-		100	Each	110.0000	3	3	013-4-23.
				Locatio	n		Loc Oty		Loc Code			,
				ST342	<del>-</del>		111		<del></del>			
•	•			0.0.2	122800			2 .			· · ·	
		•			123900			 3				
£					124221		10				<u> </u>	
											_	

												DQA:	Date	
NCR:	Yes	/ No					WORK ORDER NON-	COI	NFORM	MANCE / UI	PDATE	QA Closed:	Date	
Vork Ord	er.		·				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part	No.					•	Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		•			Des	cri	ption of work order update		Initial	А	ction	Sign &		. 1
Cause		Date	Step	Qty		c	or Non-conformance	Ct	nief Eng	Des	scription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved					·									
								FAUL	T CATE	GORY				
Land		ng Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube  Ripples in Bend  Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete nance led	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S	equence				Finish		Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

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Work Order ID: Parent Item:	97939 D4030-041							Start F	Pate: 3/12/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Asser	mbly (250)							Qty: 1.00	Required Qty: 1.00
•	Long Dasket Asset	noiy (330)				•			-	Required Qty: 1:00
AN310C4 Nut		Purchased	No			100	Each	112.0000	2	<sup>2</sup> SP
				Location	l .	Loc Qty		Loc Code		
				ST342		112				
		•			123831	12				
					124221	100				<u>X</u>
1S21042L3		Purchased	No			100	Each	6,721.0000	6	6
ut										<u> </u>
				Location	Į.	Loc Qty		Loc Code		
				FP001		3				-
					122141	3				
				GA		296				·
					122452	296				
				ST314		268				
					117885	32				
					119017	55				
					119075	138				
					123265	43				
				ST506		6154				
					123900	2154				
					124291	4000			(	<b>X</b> .
1S21042L5		Purchased	No			100	Each	912.0000	4	4
ut										(22
				Location	<u>l</u>	Loc Oty		Loc Code		13-4-23
				ST314		212				
					108827	4				<u>.                                    </u>
•	•				116548	43				·
					119109	20				
					121652	12				_ <del></del>
	,			•	122452	121				
					2937	12				<del></del>
				ST506		700			——————————————————————————————————————	<del></del>
					123900	700			<u> </u>	<u></u>

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPD	ATE			_		
												QA Closed:	Da	ate:	<u> </u>
Work Ord	Ordon					DISPOSITION									
WOIK OIG	C1.		·			Rework	1		Skid-tube	Crosstube		]	Water Jet	t	Engineering
Part i	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor		Quality
						Use-as-is	]	Therm	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR 1	No.					Work Order Update	]		Large Fab	Composite		J	Supplie	r[	
Root					Descri	ption of work order update		Initial	Acti	on	_	Sign &	-		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	on	QC Inspector
Doc/Data			6												
Equip/Tooling	Щ														
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Setup	Щ														
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Process								٠							
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Training															
Unapproved			<u> </u>	<u> </u>	<u> </u>		<u> </u>		2004		_				
							AUI	LT CATE	JORY						
Landi	$\overline{}$	l		٠,	,	General Bend	_	Grain		ſ	_	Ovalized		г	Pressure/Forced
	-	Bending	- <b>.</b> Camaa		}	BOM/Route	$\vdash$	Hardwa	**	<u>}</u>	_	Over/Under	talaranca	-	Temperature/Cure
	<u> -</u>	Centre No	ot Concei	חנדוכ נס	<sup>0/3</sup>  -	<b>-</b>	-	4		}		Part Incorre		$\vdash$	Weld
	-	Cracks	Crimanad		-	Broken/Damaged	-	<b>-</b>	on Incomplete	ncloar	_	-1		-	Wrong Stock Pulled
	_	Crushed/ Cuffs	crimpea.		<u> </u>	Burrs Contamination	-	Mainte	ions Incomplete/U	TICIEAI		Part Lost/Mi	issilig		I wrong Stock Fulled
	$\vdash$				-	Countersink	$\vdash$	Mislabe				Positioned V	Mrong		
ļ	$\vdash$	Heat Trea		Tubo	<u> </u>	Cut Too Short	$\vdash$	Misreac				Power Loss/	-		Other
		Inspectio	•	rube	-	Drill Holes	$\vdash$	Offset	ı	l	—	Trower ross/	Juige	L	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	97939						C	2/12/12	D 1 ID 1 2/10/12
Parent Item:	D4030-041							Date: 3/12/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Asse	mbly (350)					Start	<b>Qty:</b> 1.00	Required Qty: 1.00
<b>MS24665-151</b> Cotter Pin		Purchased	No		100	Each	128.0000	3	3 80
•				Location	Loc Qty		Loc Code		•
		•		GA	. 38		•		
				17566	38				
				ST323	90				
				122802	90			3	<del>×</del>
MS24665-300 Cotter Pin		Purchased	No		100	Each	235.0000	2	2 800
				<u>Location</u>	Loc Qty		Loc Code		(
				GA	37				
				118234	37				
				ST299	198				
				124555	198			)A	χ
<b>NAS1149F0432P</b> Washer		Purchased	No	,	100	Each	922.0000	6	6
		•		Location	Loc Qty		Loc Code		
				ST295	922				
				122151	2				<del></del>
				123522	4				
				123900_	516			(\( \rac{1}{2}\)X	<u></u>
				124580	400				
NAS1149F0563P Washer		Purchased	No		100	Each	766.0000	4	4 Sp/3-4-3
				<b>Location</b>	Loc Qty		Loc Code		
				ST295	766				
				121350	766			(/	<u>/X</u>

DQA:	Date:	

## **WORK ORDER NON-CONFORMANCE / UPDATE**

NCR: Yes / No QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Engineering . Water Jet Skid-tube Crosstube Rework Quality Machining Small Fab Prod. Eng. Coor. Part No. Scrap Other Thermoforming Finishing Rec/Store/Packaging Use-as-is Large Fab Composite NCR No. Work Order Update Supplier Description of work order update Sign & Initial Action Root Chief Eng Description Date Verification QC Inspector or Non-conformance Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Grain Pressure/Forced Ovalized Bend Bending BOM/Route Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped. Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Cut Too Short Misread Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Finish Out of Sequence

**Outside Dimensions** 

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	97939							
Parent Item:	D4030-041					Start D	ate: 3/12/13	Required Date: 3/12/13
Parent Item Name:	Long Basket Assembly (350)					Start (	Qty: 1.00	Required Qty: 1.00
NAS1149F0332P WASHER	Purchased	No .		100	Each	10,520.000	8	8 86
		Locat	<u>ion</u>	Loc Oty		Loc Code		
•	•	GA		194				
			122063	194				
		ST294	ŀ	323				
			122063	323			-	
		ST295		3				<u> </u>
			123352	3			**************************************	
		st510		10000				
			123900	10000			——- <del>\</del>	<del></del>
NAS1149C0432R Vasher	Purchased	No		100	Each	2,666.0000	2	28p13-4-23
		Locat	<u>ion</u>	Loc Qty		Loc Code		
		GA		5				
			121255	5				
		ST292	2	2661				
			119124	6				<del></del>
			122441	2655			— <i>Ժ</i>	<del>-X</del>

											DQA:	Date:	
NCR: Y	es ,	/ No				WORK ORDER NON-	CON	NFORM	MANCE / UP	DATE			
	·										QA Closed:	Date:	
Work Orde	r.					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
vvork Orde	'· —				<del></del>	Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	ο.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		·				Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o					Work Order Update	]		Large Fab	Composite		Supplier	
											J 6: 0		
Root						ption of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_												
Operator													
Material			:										
Setup													
Other							İ						
Process												Ì	
Supplier													
Training													
Unapproved		ļ											
						F	AUL	T CATE	GORY				
Landin	ıg Ge	ear	-			General					-	_	7
	B	ending				Bend		Grain			Ovalized		Pressure/Forced
		entre No	t Concer	ntric to (	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		racks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
1	$\neg$	rushed/(	^rimned			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	_	9	7	6	5	A	3	2	
	ITEM QTY	QTY P/N	DESCRIPTION	T					
	-041	1-043		4					•
	X	D4030-041 X D4030-043	LONG BASKET ASSY (350)	-			•		į.
		A D4030-043	LONG BASKET ASSY, LIGHT LID (350)	-	45 × 5				i
	1 1	1   D2530	HANDLE WELDMENT		E 2 30	mass.			ļ
	2 2	2 D2535	SPRING	1				Mar.	j
D	3 2	2 D2537	BUSHING		ENGLI PERENCI	le la la la la la la la la la la la la la	<b>*88</b> \$\$\ <b>\$</b> \$\$\$\\$\$ <b>\$</b>		10
	4 1	1 D3913-041	LONG BASKET BASE ASSY (350)	](	UNCOMINGILID	COFY	1/2000/0000	AND THE PARTY OF T	
	51	D3914-041	LONG BASKET.LID ASSY.(350)				WASSER ASSESSALVE	5	
	6	1 D3915-041	LIGHT LID ASSY-LONG BASKET	_	S. BILCTTO SE-D			Q /3 /	
	7 6 8 2		WASHER GAS SPRING STUD, LID	4	TO THOSE NOTE	E			
	9 2		GAS SPRING STOD, LID	4	v con agai	R		7	
	10 2		GAS SPRING WASHER	-	work or of 1979.39	1165		19	
	11 2		GAS SPRING SPACER	1	7.7.7.3.1				
	12 1	1 D3953-19	GAS SPRING BRACKET		•	12.112-04		1	_
	13 1	1 D3953-21	GAS SPRING BRACKET	]	/	5.05			
	14 1	1 D3969-3	SPRING				THE ME		
	15 4	4 AN3-14A	BOLT	1				600	
	16 2	AN3-16A	BOLT		10 P 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			N. B. W.	ľ
	17	2 AN3-20A	BOLT		图图图图图	-			
С	18 3	3 AN4-12	BOLT (DRILLED)		NEED BEEN	6		JI 79 //	c
-	19 4	2 AN5-17A	BOLT	-   182	A PART OF THE PROPERTY OF THE	( ) ( )		1 /1 //	
	20 3	2 AN5-21A 3 AN310-4	BOLT NUT, CASTELLATED	- 18			$\sim$		
	22 2		NUT, CASTELLATED	- 18			(4)		
	23 6		NUT		A STATE OF THE STA		0		14)
	24 4	4 MS21042L5	NUT	i 18	W S S S S S S S S S S S S S S S S S S S				)
	25 3	3 MS24665-151	COTTER PIN			78-1-1-1			
_	26 2		COTTER PIN	4		Kalled Fall			l
-	27 6 28 4	6 NAS1149F0432P	WASHER	4	A Separate Month	IN TEXT IN	D4030-041 L	ONG BASKET ASSY (350)	<b> -</b> -
		4 NAS1149F0563P 8 NAS1149F0332P	WASHER WASHER	4			(MESH SHO	OWN LOCALLY FOR CLARITY)	ļ
		2 NAS1149C0432R		┪					1
		<u> </u>					$\vec{n}$		
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- 1								1 (10.00.17 (('))	U I
								ECN 10-596	١ ا
								ECN 10-346	
					D4030-043 LONG BAS	KET ASSY, LIGHT LID (350)			<u> </u>
					(MESH SHOWN L	OCALLY FOR CLARITY)	OTY FOR ITEMS #30 &	#31 LINDER -043 WERE MISSING	
						·	C (B8-1); QTY FOR ITEM	#31 UNDER -043 WERE MISSING #3 WAS 4 (D6-1), ONLY 2 ARE MB SECTION C-C (D3-3).	10.07.23
ŀ							B AN5-21A BOLT WAS AN	15-19A: BOM & (D3-3).	10.04.06
							A NEW ISSUE		10.03.16
l							REV.	DESCRIPTION BY	DATE
_ A		_					DESIGN AS	DART AEROSPACE LTD	) A
^	NOTE:	<u>S:</u> FÉRIAL: N/A					DRAWN	HAWKESBURY, ONTARIO, CANADA	^
	2) FINI	SH: NONE					CHECKED (P)	DRAWING NO	REV. C
	3) TOL	ERANCES: PER DART (	QSI 018 UNLESS OTHERWISE NOTED				MFG. APPR. TEST	D4030 SH	EET 1 OF 3
	4) UNI	TS: INCHES UNLESS OT AK SHARP EDGES: N/A	THERWISE NOTED				APPROVED VY	TITLE	SCALE
		:AK SHARP EDGES: N/A NTIFICATION: N/A	1				DE APPR.	LONG BASKET ASSY (350)	NTS
	7) WE	GHT: -041: 72 lbs APPR	OX	*			5.77	COPYRIGHT © 2010 BY DART AEROSPACE LTI	
}	•	-043: 57 lbs APPR	ox				DATE 10.07.23	COPYRIGHT © 2018 BY DART AEROSPACE LTI THIS DOQUEEN IS PRINATE AND COMPONING, AND IS SUPPLED ON THE EXPRESS COM HOT TO BE USED FOR ANY PURPOSE OR COMPONING ATTE TO ANY OTHER PE	ERSON WITHOUT
		8			1		<del></del>	WRITTEN PERMISSION FROM DIART AEROSPACE LTD	J



